

Work Order ID 57354

April 6, 2010 8:28:37 AM



Page 1

Item ID: D2656-13

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 4/06/10 Start Qty: 10.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Handwritten signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2656

Rev D

100



Waterjet

FLOW WATER JET

0.00

☐ Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2656
Deburr if necessary

☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-

B 10-4-7

(12)

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

☐ Memo

0.00

Quality Control

B 10-4-7

120



QC

QC8- Inspect parts - second check

0.00

☐ Memo

0.00

Quality Control

Sw/oe/og

(12)

Work Order ID 57354

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Page 2

Item ID: D2656-13

Accept

Revision ID:

Item Name: Wearplate

Start Date: 4/06/10 Start Qty: 10.00

Required Date: 4/16/10 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

5810/04/12

12

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

810/04/12

(+12)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

START TIME:

7:30 AM

FINISH TIME:

OVEN TEMPERATURE:

320°F

710/04/13

(x12)

Work Order ID 57354

April 6, 2010 8:28:38 AM



Page 3

Item ID: D2656-13

Accept



Setup Start



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Stop



Start Date: 4/06/10 Start Qty: 10.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

BR 10-4-13

12

φ

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: FP-20

0.00

JS 10/04/13

12

φ

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

10/04/13 JS

QC

Memo

0.00

Quality Control

BS 10-4-13

12

Picklist Print

April 6, 2010 8:28:37 AM

Page 1

Work Order ID: 57354

Parent Item: D2656-13

Parent Item Name: Wearplate

Comments: IPP: F 02.10.25 Re-format KJ/RF
IPP Rev:G Now on Waterjet 06-07-03 JLM

Start Date: 4/06/10

Required Date: 4/16/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No			100	sf	100.0000	8.5000	10.3		



1010/1025 SHEET



18 10-4-7

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111410

100

100

18

111410

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

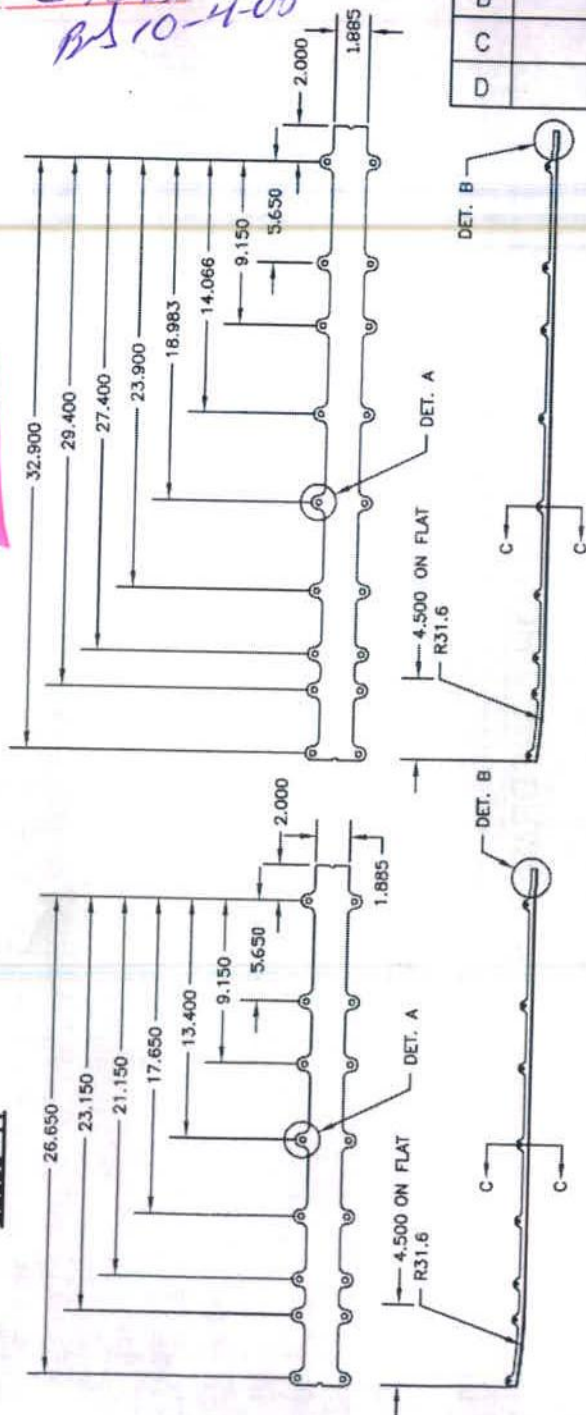


ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 57354

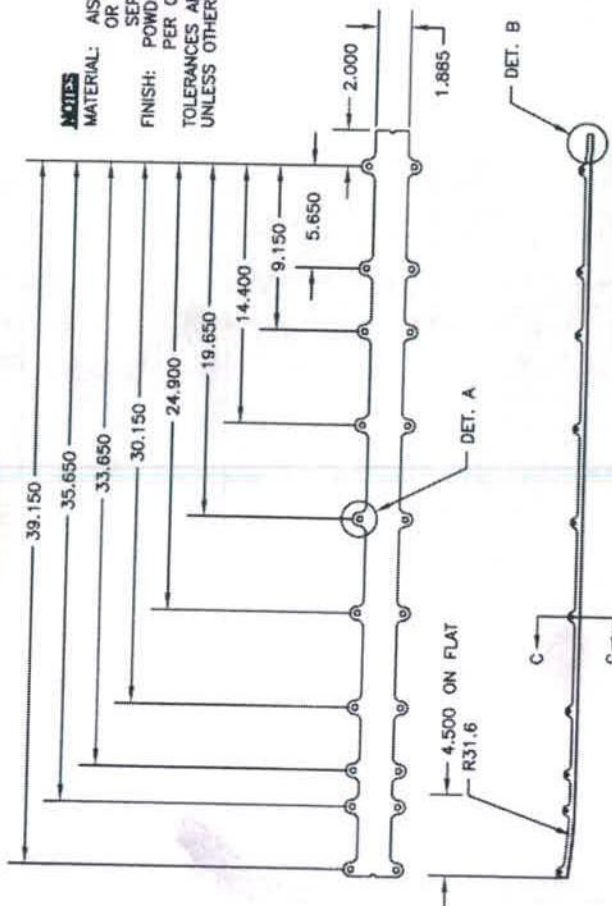
BS 10-4-05

D2656-13



D2656-11

D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05-09-08

DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2656
DATE	05.08.17	TITLE	WEARSHOE	REV. D SHEET 1 OF 4
				SCALE 1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

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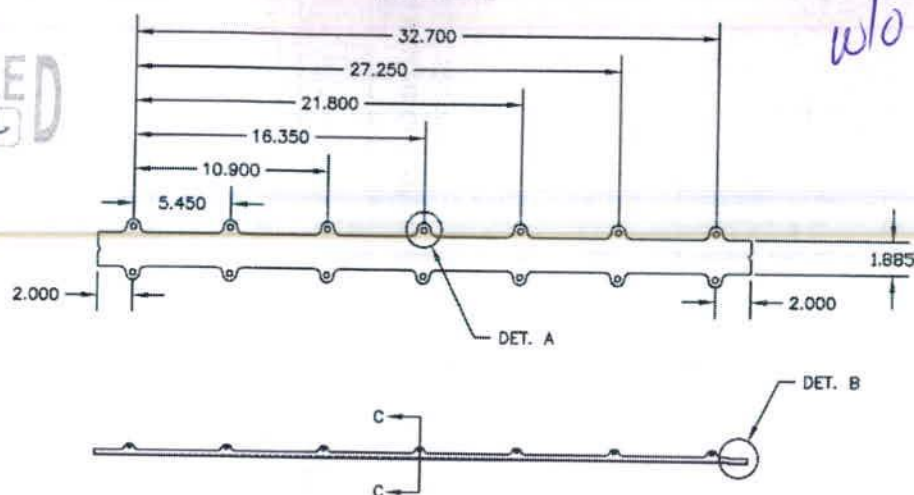
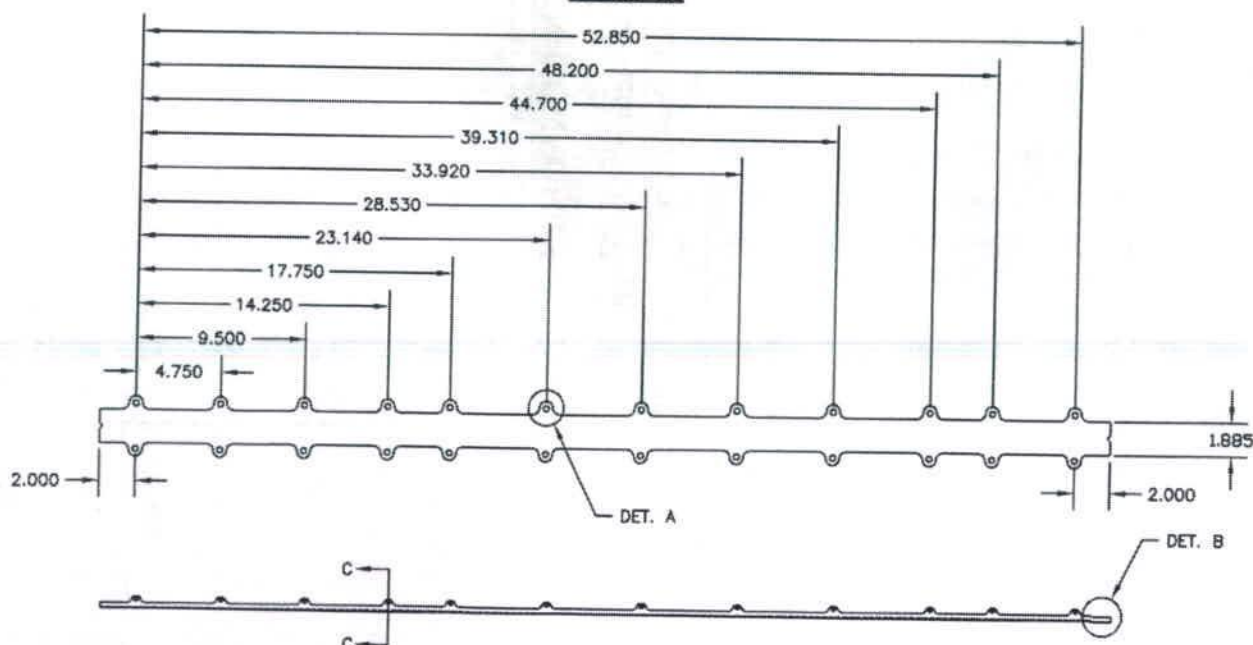
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

RELEASED
DS 01-06 *[Signature]***D2656-21****D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

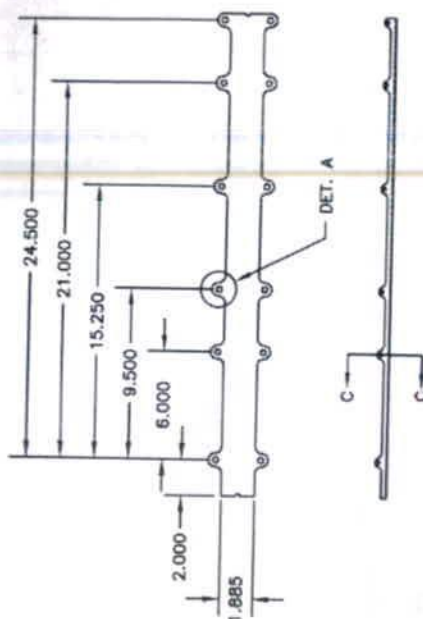
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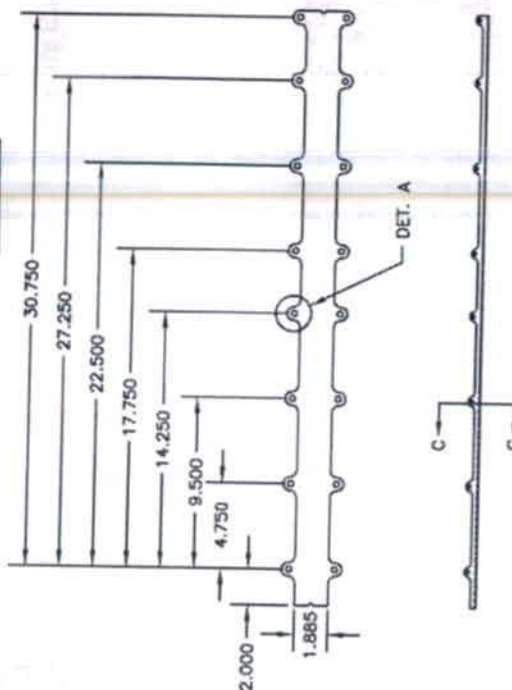
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

W/O 57354

D2656-33

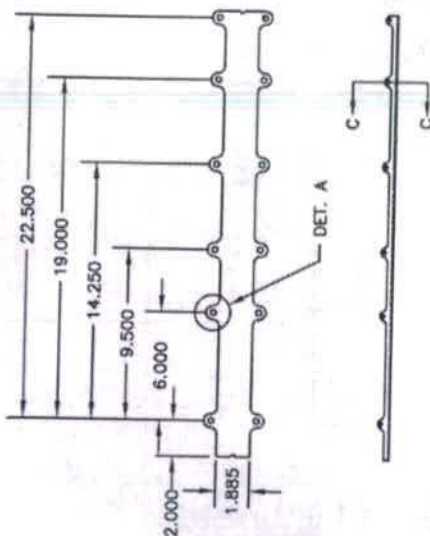


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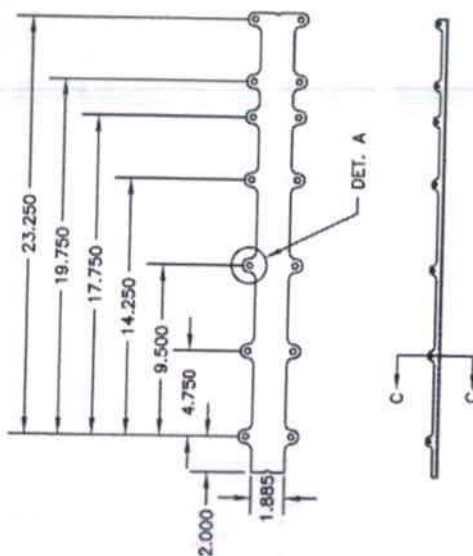


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05.07.06

D2656-31



D2656-35



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

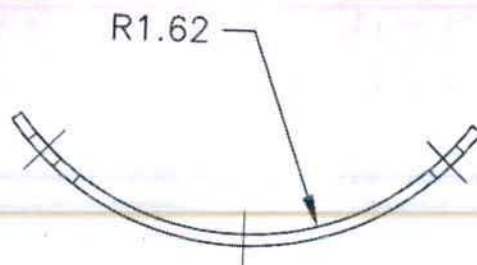
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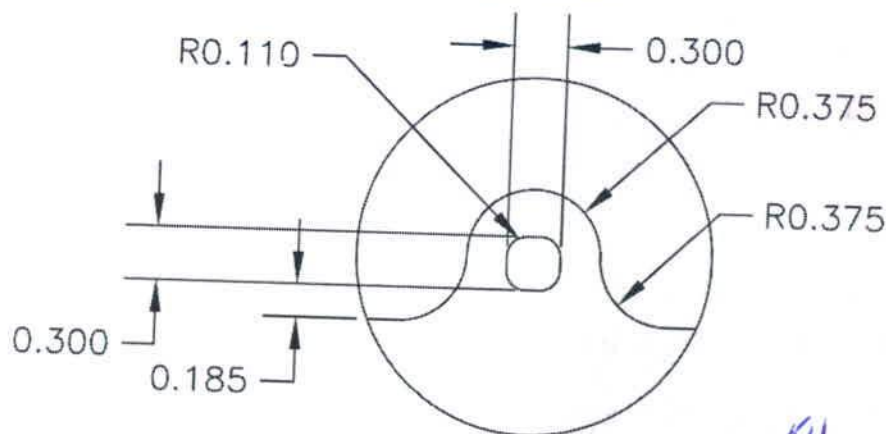
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DATE 05.08.17	TITLE WEARSHOE		SHEET 4 OF 4
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SECTION C-C

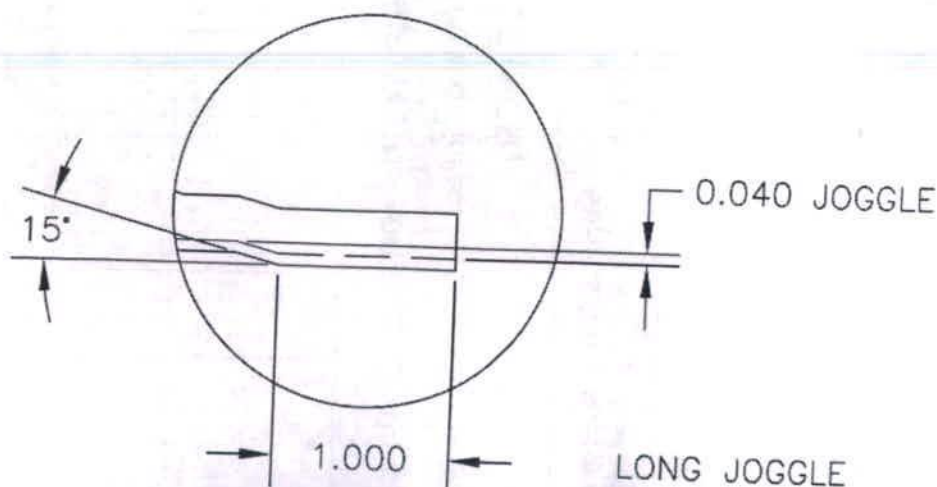


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DETAIL A



DETAIL B



w/o 57354

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